

Date: Monday, 7/16/2007 2:40:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GAS SPRING
Job Number : 33533	
Estimate Number : 12941	
P.O. Number : <i>N/A</i>	Part Number : D355211
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3552 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 33521	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/23/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.07.17	
Comment : Est Rev A New Issue 06-11-13 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: *4212*
 Purchase Part Number: B8-240-575-150N
 Supplier: LS Technologies
 Certificate of conformity is required

*C 207/07/19**(20)*

2.0	B8 240 575 150N	CARBON STEEL GAS SPRING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 CARBON STEEL GAS SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

*C 207/12/13**(20)*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Test for correct pressure

En 07/08/02 (420) can be used

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *[Signature]**07/08/02 (20)*

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Drawing Name: GAS SPRING

Job Number: 33533

Part Number: D355211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

02/08/03

Job Completion



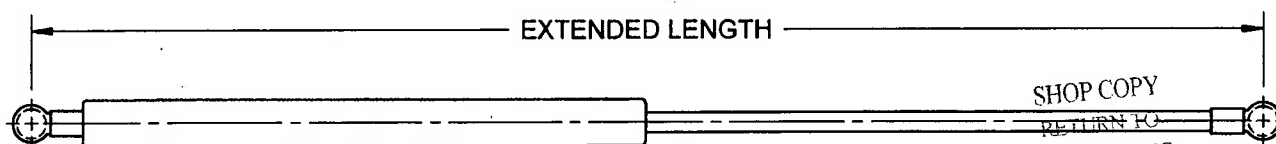
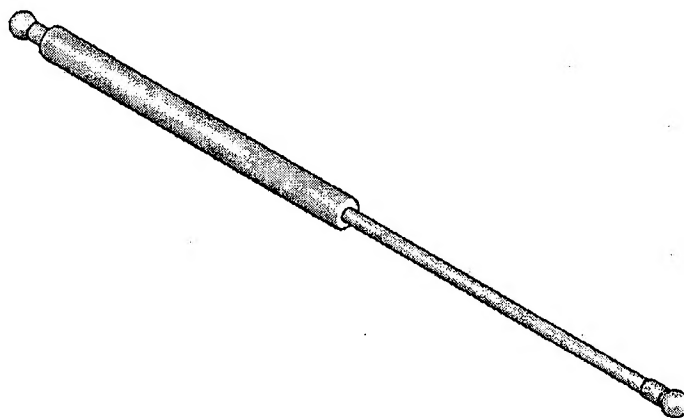
20-07-08-02



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>TH</i>	DRAWING NO. D3552	REV. C SHEET 1 OF 1
DATE 07.06.01		TITLE GAS SPRING SCALE NTS	
REV	DATE	DESCRIPTION	
A	06.09.15	NEW ISSUE	
B	06.10.24	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	
C	07.06.01	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	

RELEASED
07.07.11
PER BAW #1009

SPECIFICATION CONTROL DRAWING



D3552-X GAS SPRING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33533**

DART P/N	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	C8-220-530-070N
D3552-3	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	C8-175-430-150N
D3552-7	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	B6-220-530-070N
D3552-9	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N
D3552-11	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	B8-240-575-150N

NOTE:

1) IDENTIFY WITH DART P/N "D3552-X" USING WHITE FINE POINT PERMANENT INK MARKER

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Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: info@lsttechnologies.ca
Web: www.lsttechnologies.ca

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: B8-240-575-150N Carbon Steel Gas Spring

Country of Manufacture : Canada

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 4212
Invoice # 3794

L S Technologies Inc Canada

Nolan Fehr
Manager



- 1 - 46 lbs / 206 W
- 2 - 188 W / 42 lbs
- 3 - 411 lbs / 184 W
- 4 - 46 lbs / 206 W
- 5 - 45 lbs / 201 W
- 6 - 42 lbs / 188 W
- 7 - 45.5 lbs / 204 W
- 8 - 41 lbs / 184 W
- 9 - 40 lbs / 179 W
- 10 - 54 lbs / 242 W
- 11 - 42 lbs / 188 W
- 12 - 45 lbs / 201 W
- 13 - 45 lbs / 201 W
- 14 - 55 lbs / 246 W
- 15 - 42 lbs / 188 W
- 16 - 44 lbs / 197 W
- 17 - 45 lbs / 201 W
- 18 - 42 lbs / 188 W
- 19 - 41 lbs / 184 W
- 20 - 50 lbs / 224 W

Tested on Scale
Sth-01

$$158 W \div 4.488 = 331 \text{ lbs}$$

20/09/02
or